

# Work Order ID 54096

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Item ID: D412-666-011  
Revision ID: C1  
Item Name: Gross Weight Towing

Accept



Setup Start



Stop



Start Date: 11/27/09 Start Qty: 3.00  
Required Date: 11/30/09 Req'd Qty: 3.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: *[Signature]*  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-666	Rev C1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP412-666-011

CHG 004

*8 02/12/03*

*for BG 09/11/30*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*9/12/3*

*(3) SD*

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*=> 8 09/10/03*

*(73) 9*

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Start Date: 11/27/09 Start Qty: 3.00  
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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
130	Packaging	0.00
Packaging	Memo	0.00
Packaging	Identify and pack for shipping as per PPP D412-666-011 Location: _____ [1] PPP Rev: _____	

Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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4112/4 (3)

140	QC21- Final Inspection - Work Order Release	0.00
QC	Memo	0.00
Quality Control		

09/12/09  
MF 09-12-031

# Picklist Print

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Work Order ID: 54096

Parent Item: D412-666-011RevC1

Parent Item Name: Gross Weight Towing

Comments:



Start Date: 11/27/09

Required Date: 11/30/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN6-15A 1 x4  
Bolt  
Purchased

No

Each

56.0000

12.0000

9/12/13 SLP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

56

108744

7

111425

49

Each

60.0000

12.0000

12 x SLP

9/12/13 SLP

AN6-45A 24  
Bolt  
Purchased

No

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

60

110002

1

113222

9

113256

50

Each

855.0000

24.0000

5 x SLP

9/12/13 SLP

AN960JD616 16  
Washer  
Purchased

No

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

855

112314

55

112828

500

113149

300

24 SLP

# Picklist Print

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Work Order ID: 54096

Parent Item: D412-666-011RevC1

Parent Item Name: Gross Weight Towing

Comments:

Start Date: 11/27/09

Required Date: 11/30/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2888RevA2

X2

Manufactured

No

Each

0.0000

6.0000



BS4021

9/12/350

Lug

MS21042L6

X4

Purchased

No

Each

528.0000

12.0000



9/12/3

SV

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

528

105077

22

110002

5

111548

8

111578

400

112492

93

12x5

(34)

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Shop Packet Print

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# 1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-XXX OR D204-635-XXX OR D412-742-XXX SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

# 2.0 PARTS LIST:

QTY/ -011/	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
/2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-45A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)

REFERENCE ONLY

# 3.0 WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

# 4.0 PROCEDURE:

- 1) REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- 2) INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-45A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- 3) TORQUE BOLTS TO 95-110 in-lb (10.7-12.4 N-m).

# 5.0 NOTE:

IT IS ACCEPTABLE TO REPLACE THE AN6-15A/45A BOLTS WITH LONGER OR SHORTER AN6 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD616 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

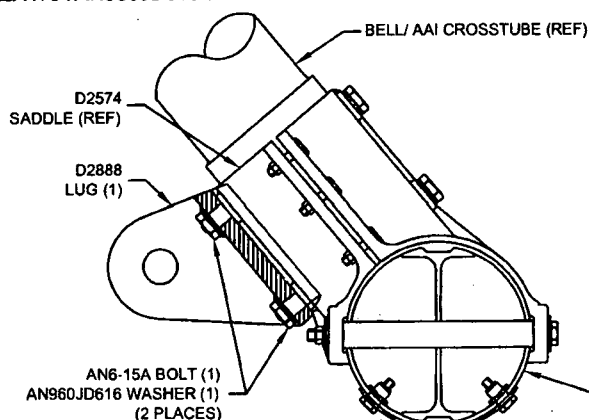


FIGURE 1  
(BELL/AAI CROSSTUBES)

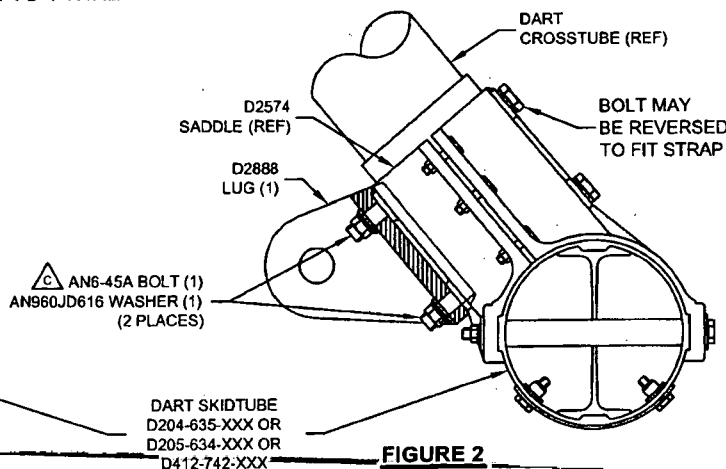


FIGURE 2  
(DART CROSSTUBES)

C	- AN6-45A WAS AN6-43A, ADD NOTES - TO ENSURE COMPATIBILITY WITH D412-742-011/-013 - ESTIMATE (PARTS/PICK LIST) IS AFFECTED	MB	07.08.09
B	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	CP	02.03.04
A	NEW ISSUE	CP	99.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. REV. C	
MFG. APPR.		D412-666 SHEET 1 OF 1	
APPROVED		TITLE SCALE	
DE APPR.		412 GROSS WEIGHT TOWING KIT 1:4	
DATE	07.08.10	COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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